

Date: Tuesday, 15/08/2006 7:18:38 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28175-2
Estimate Number : 10779
P.O. Number : N/A
This Issue : 15/08/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 27792
Drawing Name : STEP WELDMENT
Part Number : D3463041
Drawing Number : D3463 REV.B
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 31/08/2006 Qty: 3 Um: EACH
Written By :
Checked & Approved By :
Comment : EST REV. A 05.11.18 new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 238806 SS DOWEL PIN 1" LONG



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|----------------------|--------|
| 2 | 238-806 | SS DOWEL PIN 1" LONG | M19080 |

PD 06-08-09 (2)

2.0 D34533 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D3453-3 | Clevis | B28189 |

PD 06-08-09 (2)

3.0 D34637 Drag Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------------|
| 1 | D3463-7 | Drag Arm | B28195-1 B27804-1 |

PD 06-08-09 (2)

4.0 D34631 Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------------|
| 1 | D3463-1 | Arm | B28192-1 B27802-1 |

PD 06-08-09 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 28175

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3463-3

Step

B28214 -> 1
B21535 -> 1

PD 06-09-08 (2)

6.0

D34635F

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3463-5

Step Flat Pattern

B28194

PD 06-09-08 (2)

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3453-5

Plug

B27800

PD 06-09-08 (2)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463 using DT8875

PD 06-09-08 (2)

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

MA 06/09/08 (2)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FL 06-09-11 (2)

Date: Tuesday, 15/08/2006 7:18:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 28175

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

FC 06 09 11 (2)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SP 06/09/11 (2)
SP 06/08/11

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SP 06/08/11 (2)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/09/13 (2)

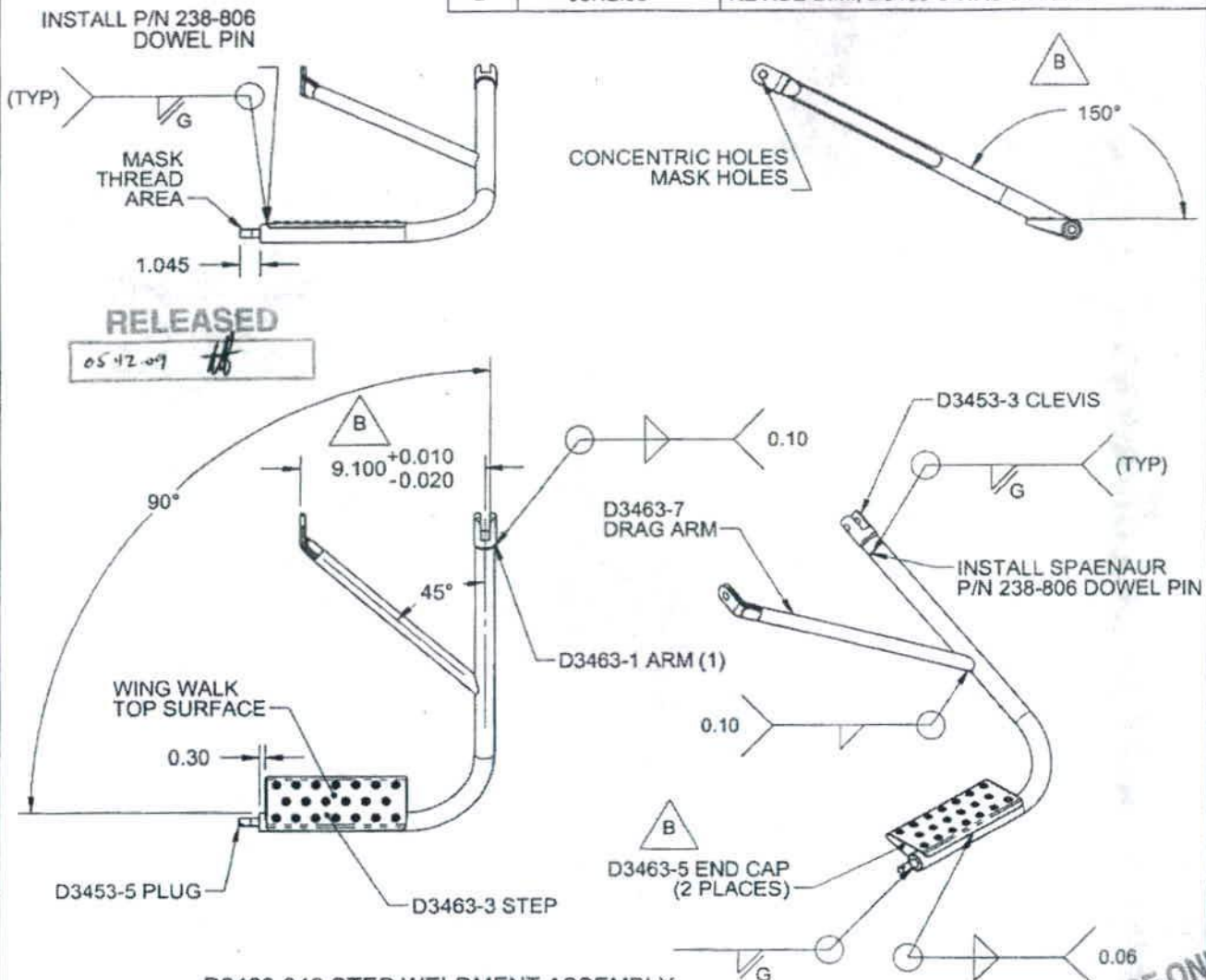
Job Completion



W 06-09-13

DART

| | | | |
|-------------------------|----------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 1 OF 4 |
| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:8 |
| A | 05.09.20 | NEW ISSUE | |
| B | 05.12.05 | REVISE DIM.; D3463-5 WAS D3463-5F | |



D3463-042 STEP WELDMENT ASSEMBLY
D3463-041 OPPOSITE

NOTES:

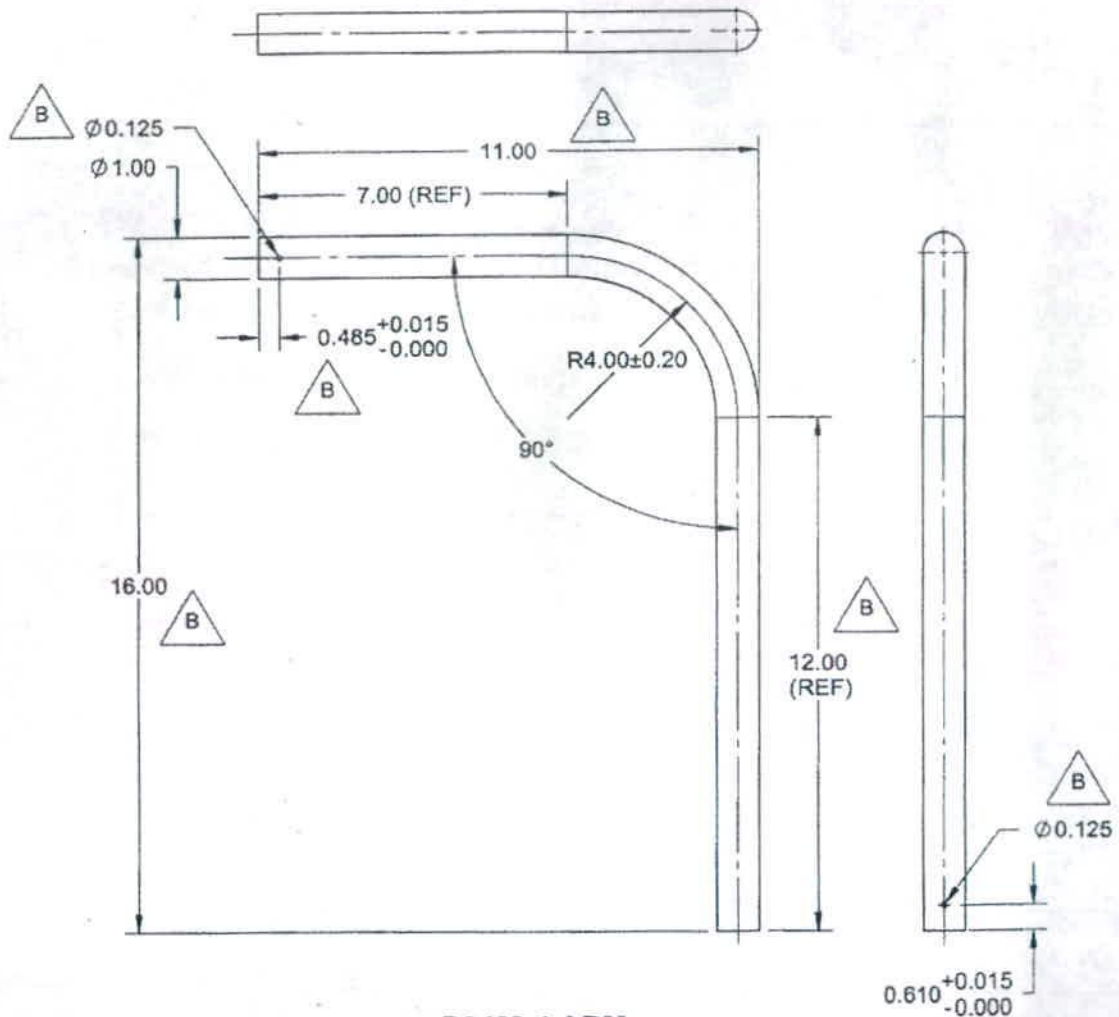

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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DART

| | | | |
|--|---|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED  | APPROVED  | DRAWING NO. D3463 | REV. B SHEET 2 OF 4 |
| DATE 05.12.05 | TITLE STEP WELDMENT | | SCALE 1:4 |

RELEASED05.12.09 **D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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05.12.09



1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

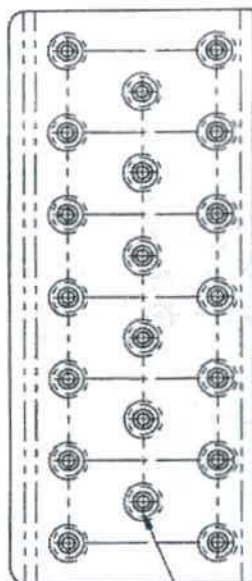
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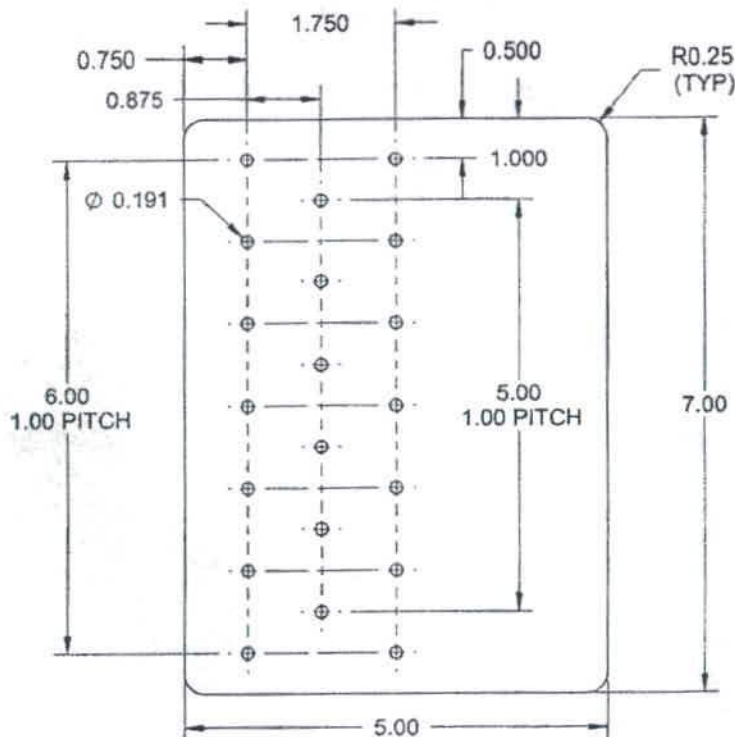
| | | | |
|------------------|------------------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 4 OF 4 |
| DATE 05.12.05 | TITLE STEP WELDMENT | | SCALE 1:2 |

RELEASED

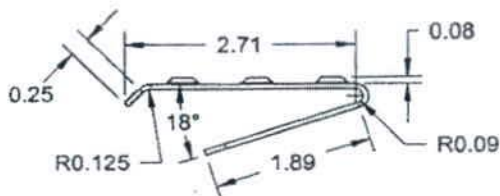
05.12.05 #



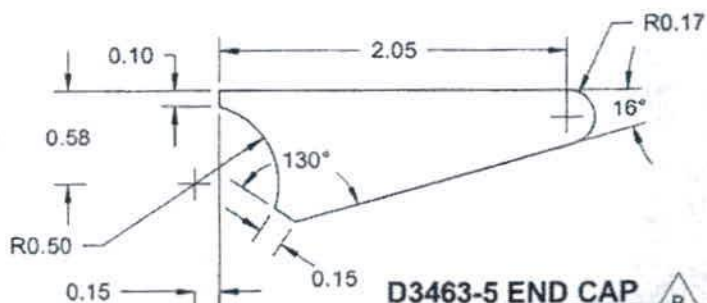
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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